

UNITED STATES DEPARTMENT OF AGRICULTURE  
FOOD SAFETY AND INSPECTION SERVICE  
WASHINGTON, DC

# FSIS NOTICE

37-15

7/1/15

## MODERNIZATION OF POULTRY SLAUGHTER INSPECTION: POST-MORTEM INSPECTION FOR NEW POULTRY INSPECTION SYSTEM

### I. PURPOSE

A. This notice instructs Public Health Veterinarians (PHVs) and online and offline inspection program personnel (IPP) how to perform online and offline post-mortem inspection procedures at young chicken and turkey slaughter establishments operating under the New Poultry Inspection System (NPIS). These instructions are to be implemented when an establishment converts to and starts operating under NPIS.

B. PHVs and IPP are to continue to follow instructions on how to perform ante-mortem inspection procedures and verify Good Commercial Practices (GCP) in sections VI and VII of [FSIS PHIS Directive 6100.3](#), *Ante Mortem and Post Mortem Poultry Inspection*.

### II. BACKGROUND

A. On August 21, 2014, FSIS published a final rule to modernize poultry slaughter inspection (see *Modernization of Poultry Slaughter Inspection*, [79 FR 49565](#)). The rule went into effect on October 20, 2014. The final rule establishes a new inspection system called NPIS for the inspection of young chickens, and all turkeys. NPIS is in addition to, not a replacement for, the current Streamlined Inspection System (SIS), New Line Speed Inspection System (NELS), New Turkey Inspection System (NTIS), or Traditional Inspection system.

B. Establishments that slaughter classes of poultry other than young chickens and turkeys may request a waiver of slaughter regulations in accordance with the *Salmonella* Initiative Program (SIP) ([76 FR 41186](#) July 13, 2011) in order to operate under NPIS.

C. Under NPIS, one inspector is assigned to perform online carcass inspection (CI) duties, and one inspector is assigned to offline verification inspection (VI) duties for each evisceration line. Consumer Safety Inspectors (CSIs) are assigned to the VI and CI positions, and they work together with the PHVs to ensure that poultry products leaving the slaughter line are safe and wholesome. Inspectors assigned to establishments operating under NPIS will be trained to perform both CI and VI duties.

D. Under NPIS, the CI duties include a continuous online inspection of each carcass at a fixed location immediately before the chiller with a focus on food safety to determine whether each carcass is not adulterated. Online CSIs are presented with carcasses that have been sorted, trimmed, and reprocessed by establishment employees, and thus CSIs are to focus on identifying carcasses affected with food safety conditions.

E. The offline CSIs perform VI duties under NPIS that consist of offline inspection activities such as monitoring and evaluating establishment process controls and verifying that good commercial practice is being followed. CSIs perform offline activities throughout the slaughter area and along the evisceration and kill lines to verify compliance with sanitation standard operating procedures (Sanitation SOPs),

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sanitation performance standards (SPS), HACCP regulatory requirements, and good commercial practice. The inspectors assigned VI duties also conduct verification checks of carcass samples collected just before the CI station to ensure that the establishment is effectively sorting carcasses, and that it is producing products that comply with the Agency's zero visible fecal tolerance and other performance standards.

F. A significant feature of the final rule applicable to all poultry slaughter systems is that fecal contamination is to be prevented. Consequently, FSIS is taking steps to verify this new regulatory requirement (9 CFR 381.65(g)) particularly with a focus on ensuring that sanitary dressing practices are in control and preventing fecal contamination throughout the slaughter operations.

G. The effective date of the new requirements is the date the establishment starts to operate under NPIS.

### **III. CSI RESPONSIBILITIES FOR CONDUCTING ONLINE POST-MORTEM INSPECTION UNDER NPIS**

A. The CSI is stationed on the production line at a fixed point before the chiller and after the establishment has completed all sorting, trimming, and reprocessing activities as prescribed in 9 CFR 381.76(b)(6)(ii)(A).

B. The online CSI is to visually inspect each carcass to determine whether the carcass is adulterated either because of a food safety condition or other condition such as generalized Inflammatory Process (IP) that warrants condemnation of the entire carcass. The CSI is to follow procedures in paragraph D. of this section to condemn carcasses affected with condemnable conditions. If the CSI is unable to determine whether the entire carcass is condemnable, the CSI is to direct the establishment to hang back the carcass for PHV disposition.

C. If the online CSI identifies a carcass with food safety defects, i.e., a carcass contaminated with feces or with septicemia or toxemia (Sep/Tox), the CSI is to:

1. Stop the evisceration line and direct the establishment to hang back the affected carcass for condemnation or reprocessing as applicable;
2. Restart the line once the carcass is removed from the evisceration line;
3. If the establishment has a monitoring or Critical Control Point (CCP) to prevent fecal contamination on carcasses or to prevent Sep/tox carcasses from entering the chiller that is located before the CI inspection station, and none between the CI inspection station and the chiller, then document his or her finding of a food safety defect on a Noncompliance Record (NR) after getting off-line. The CSI is to use the Public Health Information System (PHIS) Poultry NPIS Zero Tolerance Food Safety Verification task to document finding the Sep/Tox carcass or carcass contaminated with fecal material.
  - a. If the CSI finds a Sep/Tox carcass she or he is to describe the Sep/Tox carcass, state that the establishment is not preventing carcasses with septicemic and toxemic conditions from entering the chiller, and cite 9 CFR 381.76(b)(6)(ii)(C) and 381.83 on the NR.
  - b. If the CSI finds a carcass with visible fecal contamination she or he is to describe the fecal contamination, state that the establishment is not preventing carcasses with fecal material from entering the chiller, and cite 9 CFR 381.65(f) on the NR.
  - c. The CSI is to verify the establishment's corrective actions as follows:

- i. If the establishment's written procedures are incorporated into its HACCP plan, then the CSI is to perform the PHIS Slaughter HACCP Verification task to verify the corrective actions meet the requirements of 9 CFR 417.3(a).
  - ii. If the establishment's written procedures are incorporated into a Sanitation SOP, then the CSI is to perform the PHIS Operational SSOP Review and Observation task to verify corrections meet the requirements of 9 CFR 416.15.
  - iii. If the establishment's written procedures are incorporated into another prerequisite program, then the CSI is to perform the PHIS Slaughter HACCP Verification task to verify corrective actions meet the requirement of 9 CFR 417.5(a)(1).
4. If the establishment's monitoring or CCP to prevent food safety defects from entering the chiller is located after the CI station, then the CSI is to stop the line for removal of the carcass and notify the PHV. An NR is not written, but the PHV or designee is to perform a directed Poultry Sanitary Dressing task and other PHIS tasks for verifying that the establishment takes steps to meet the new requirement of preventing fecal contamination and enteric pathogens throughout the slaughter process (9 CFR 381.65(g)). Other PHIS verification tasks are based on how the establishment has incorporated its written procedures for preventing enteric pathogen and fecal contamination throughout the slaughter process. If Sep/tox is found, then the PHV or designee is to verify the establishment's sorting is in control (9 CFR 381.76(b)(6) ii)) using PHIS tasks based on how the establishment has incorporated its written procedures in its HACCP system.
5. The online CSI is to record any finding of fecal contamination on the FSIS Form 6000-36, NPIS Lot Tally Sheet by entering a hash mark under Special Survey codes found at bottom of the form.

D. If the online CSI identifies a carcass affected with non-food safety animal disease condition that warrants condemnation of the entire carcass, he or she is to stop the line and direct the establishment to hang back the carcass for condemnation. The CSI is to condemn carcasses that clearly exhibit condemnable conditions. Criteria for carcass condemnation are found in the following regulations and other criteria in this notice.

1. Skin leukosis (9 CFR 381.82);
2. Airsacculitis (generalized) (9 CFR 381.84);
3. Inflammatory Processes (generalized) (9 CFR 381.86);
4. Tumors that have spread (metastases) or affect the carcass in size, position or nature (9 CFR 381.87) and keratoacanthoma tumors that have coalescing tumors (9 CFR 381.87);
5. Bruises (generalized) (9 CFR 381.89);
6. Cadavers (9 CFR 381.90);
7. Mutilation (excessive) 9 CFR 381.91(a);
8. Overscald (excessive) 9 CFR 381.92; and
9. Certain other conditions, e.g., inflammatory process, that if generalized to the extent that the carcass cannot be trimmed or salvaged, the entire carcass is to be condemned by the CSI.

**NOTE:** If the online CSI identifies a dead on arrival (DOA) carcass (9 CFR 381.71(a)), the CSI is to stop the line and direct the establishment management to hang back the carcass for condemnation. The CSI is to restart the line after the carcass is removed from the line. The CSI is to notify the PHV or VI who are to verify that the establishment's controls for preventing DOAs from entering the establishment are effective. (See [FSIS PHIS Directive 6100.3.](#))

E. The online CSI is to record the number of carcasses that the CSI condemns online but not the cause of condemnation, on the FSIS Form 6000-36 NPIS Lot Tally Sheet, as a hash mark.

F. The online CSI is to notify the PHV or designee when the CSI believes that a carcass-by-carcass inspection cannot be adequately performed within the time available because of the manner in which the birds are being presented to the CSI, or because of factors that may indicate a loss of process control, such as persistent, unattended defects. The CSI is to be aware that proper presentation of carcasses under the NPIS is described in 9 CFR 381.76 (b)(6)(iii) and requires that:

1. Each carcass, except carcasses and parts identified as "major portions" under 9 CFR 381.170 (b) (22), must be held by a single shackle;
2. Both hocks (when available) of each carcass are held by the shackle;
3. The back side of the carcass must face toward the inspector; and
4. There must be minimal carcass swinging motion.

G. The online CSI is to notify the PHV or designee if the CSI observes persistent, unattended non-food safety trim and processing defects on carcasses.

H. Examples of non-food safety trimming and processing defects include: sores, breast blisters, bruises, trimmable tumors, trimmable synovitis or air sacculitis, compound fractures, scabs, abscesses, dermatitis, salpingitis, nephritis, kidney removal where applicable, oil glands, lungs, intestines, cloaca, bursa of Fabricus, esophagus, crop, trachea, and feathers. Trim and processing defects that are persistent include observing numerous carcasses, either in a row or in clusters that have obvious severe or numerous problems that could affect the usability of the product. Examples of obvious or severe problems include observing obvious sores and scabs on the skin indicating deep tissue sores with or without inflammatory process (IP) involvement. A defect is persistent if, for example, IPP find multiple broken crops, especially if there is feed (ingesta) present that would indicate loss of process control related to proper withdrawal of feed. Defects are unattended if the establishment fails to effectively address the problem even though it has had an opportunity to do so. The PHV or designee is to further assess the situation as described in section V.E.

#### **IV. CSI RESPONSIBILITIES FOR CONDUCTING OFFLINE VERIFICATION INSPECTION UNDER NPIS**

A. The offline CSI conducts offline food safety related verification inspection activities to verify that an establishment complies with regulatory requirements in the HACCP system in accordance with [FSIS Directive 5000.1](#). The HACCP system includes the HACCP Plan and Sanitation SOPs or other prerequisite programs.

B. The offline CSI is to verify that the establishment has developed written procedures to prevent carcasses with visible fecal contamination from entering the chiller and has incorporated them into its HACCP system (i.e. HACCP plan, Sanitation SOPs, or other prerequisite programs) and is to document any non-compliances by following instructions in FSIS Notice 64-14 *Modernization of Poultry Slaughter Inspection: Verifying an Establishment's Procedures for Preventing Contamination by Enteric Pathogens and Fecal Material*.

C. The offline CSI is to verify that the establishment has developed written procedures for preventing carcasses with Sep/Tox from entering the chiller and has incorporated the procedures into its HACCP system (i.e., HACCP plan, Sanitation SOPs, or other prerequisite programs) and is to document any non-compliances by following instructions in [FSIS Directive 5000.1](#).

D. The offline CSI is to verify offline that food safety hazards, i.e., Sep/Tox carcasses (9 CFR 381.83) and carcasses with fecal contamination (9 CFR 381.65(f)), are prevented from entering the chiller by examining sets of 10 carcasses using the PHIS Poultry NPIS Zero Tolerance Food Safety Verification task.

1. Each day, the offline CSI is to conduct eight 10 bird carcass checks (that is, a 10 bird check each hour) for each evisceration line for every shift. In large establishments with many eviscerating lines the PHV may schedule random times for each CSI.
2. The offline CSI is to conduct food safety checks by randomly selecting 10 carcasses just before the CI station and examining them offline to verify that the establishment's process produces product free of visible fecal and Sep/Tox contamination before the chiller. The CSI is to examine each 10-bird sample set at the pre-chill offline VI station to identify feces according to the identification guidelines for feces (see Attachment 1) and is to identify Sep/Tox carcasses according to disposition criteria in 9 CFR 381.83. The CSI is to use the following inspection procedure to examine each carcass.
  - a. Outside back: While holding the carcass, with the back of the carcass toward the inspector and starting at the hock area, observe the hocks, back part of the legs, tail area, back of the carcass, and top side of the wings;
  - b. Outside Front. Turn the carcass and observe the bottom side of the wings, breast, and front part of the legs;
  - c. Inside: Observe the inside surfaces of the carcass and the abdominal flaps and fat; and
  - d. Neck Flap Area: Observe the neck flap and the thoracic inlet area.
3. If the offline CSI performs the PHIS Poultry NPIS Zero Tolerance Food Safety Verification task and does not observe fecal material or Sep/Tox contamination on any of the carcasses, she or he is to indicate in PHIS that he/she verified compliance with 9 CFR 381.76(b)(6)(ii)(C) and 381.65(f) and mark the task as "Inspection Completed."
4. If the offline CSI detects food safety conditions on any of the 10 birds in a set, she or he is to verbally notify the establishment of the noncompliance with 9 CFR 381.65(f) or with 9 CFR 381.83 and 381.76(b)(6)(ii)(C) and complete the PHIS Poultry NPIS Zero Tolerance Food Safety Verification task by writing an NR.
  - a. If the CSI finds fecal material on a carcass, she or he is to describe the fecal material and state on the NR that the establishment is not preventing carcasses with fecal material from entering the chiller and cite 9 CFR 381.65(f).
  - b. If the CSI finds a Sep/Tox carcass, she or he is to describe the carcass and state on the NR that the establishment is not preventing Sep/Tox carcasses from entering the chiller and cite 9 CFR 381.83 and 9 CFR 381.76(b)(6)(ii)(C).
  - c. If the CSI finds fecal material on one or more carcasses and one or more Sep/Tox carcasses in the same 10-bird sample, she or he is to document a NR and cite 9 CFR 381.65(f), 381.83, and 381.76(b)(6)(ii)(C).

5. After notifying the establishment of the noncompliance, the offline CSI is to verify that the establishment's corrective actions are effective.
  - a. If the establishment's written procedures are incorporated into its HACCP plan, then the CSI is to perform the PHIS Slaughter HACCP Verification task to verify that the corrective actions meet the requirements of 9 CFR 417.3(a).
  - b. If the establishment's written procedures are incorporated in to its Sanitation SOP, then the CSI is to perform the PHIS Operational SSOP Review and Observation task to verify that the corrections meet the requirements of 9 CFR 416.15.
  - c. If the establishment's written procedures are incorporated into another prerequisite program, then the CSI is to perform the PHIS Slaughter HACCP Verification task to verify that the corrective actions meet the requirements of 9 CFR 417.5(a)(1).

E. The offline CSI is to condemn any Sep/Tox carcasses found on the 10 bird verification check and record the number condemned, but not the cause of condemnation, on the FSIS Form 6000-36, NPIS Lot Tally Sheet.

F. If the offline CSI observes carcasses affected with non-food safety animal disease conditions that warrant condemnation of the entire carcass as listed in section III.D. during the performance of the PHIS Poultry NPIS Zero Tolerance Food Safety Verification task, she or he is to follow the instructions below.

1. The CSI is to condemn the carcass and record the condemnation but not the cause of the condemnation using a hash mark on the FSIS Form 6000-36, NPIS Lot Tally Sheet. The CSI is to retain the affected carcass for veterinary disposition if she or he has a question as to whether the entire carcass is condemnable.
2. If the CSI finds more than two carcasses in the 10 bird set with a disease condition warranting condemnation of the entire carcass, then the CSI is to write an NR and use the appropriate PHIS task according to the location in the establishment's HACCP system where the establishment has elected to include its sorting procedures (9 CFR 381.76(b)(6)(ii)(C)).
3. On the NR, the CSI is to describe observations of the disease condition warranting condemnation of the entire carcass, citing the appropriate regulation for the disease condition. The CSI is also to cite 9 CFR 381.76(b)(6)(ii)(A) and state that the establishment did not dispose of carcasses and parts exhibiting likely condemnable conditions before presenting carcasses to the online CSI, and that the sorting activities are not effective.

G. Offline CSIs are to conduct a routine PHIS Poultry Ready-to-Cook (RTC) task as scheduled to verify that the establishment, as required by 9 CFR 381.76(b)(6)(ii)(D), maintains records to document that products resulting from its slaughter operations meet the definition of RTC poultry in 9 CFR 381.1. CSIs are to follow the instructions for verifying this requirement in the [FSIS Notice 38-15](#) *Modernization of Poultry Slaughter Inspection: Verification that an Establishment Operating under the New Poultry Inspection System is Producing Ready-to-Cook Poultry*.

H. If the CSI observes persistent, unattended non-food safety trim or processing defects on carcasses during the performance of the PHIS Poultry NPIS Zero Tolerance Food Safety Verification task, after completing the task, the CSI is to orally notify the establishment management and the PHV that the products resulting from the establishment's slaughter operation may not meet the definition of RTC poultry in 9 CFR 381.1 and thus are not meeting the requirement in 9 CFR 381.76(b)(6)(ii)(D). The PHV is to evaluate the situation to determine whether the process is in control as described in section V.E. and in the [FSIS Notice 38-15](#).

I. Offline CSIs are to use the PHIS task applicable to where the establishment's procedures and processes are incorporated into its HACCP system (HACCP plan and sanitation SOPs or other prerequisite programs) to verify the requirements listed below. Verification activities by the offline CSI include, but are not limited to, evaluating establishment records, observing establishment employees perform monitoring tasks according to written procedures or processes, and inspecting carcasses and parts to ensure that adulterated carcasses, parts, tissues, or exudates are removed and disposed of. CSIs are to verify that the establishment:

1. Conducts sorting activities for all carcasses with associated viscera, disposing of carcasses and parts exhibiting likely condemnable conditions and conducting appropriate trimming and reprocessing activities before carcasses are presented to the online CSI (9 CFR 381.76(b)(6)(ii)(A)). CSIs are to complete the applicable PHIS task by writing an NR if the offline CSI finds the criteria in the establishment's sorting procedures is exceeded and cite 9 CFR 381.76(b)(6)(ii);
2. Monitors carcasses after the completion of trimming, washing, or a combination of trimming and washing followed by chlorine (or other approved Offline Reprocessing (OFLR) antimicrobial rinse) to ensure that the OFLR effectively removes visible contamination from internal and external surfaces. (9 CFR 381.91(b)). The establishment makes available reprocessed carcasses for CSIs to select a representative sample before returning the carcasses to production. (See FSIS Notice 50-14, *Modernization of Poultry Slaughter Inspection: Verification of Online Reprocessing and Offline Reprocessing Antimicrobial Intervention Systems*).
3. After completing offline reprocessing and salvaging activities, as required by 9 CFR 381.76(b)(6)(ii)(B), returns carcasses or major portions (as defined in 9 CFR 381.170(b)(22)) back to the evisceration line before the CI. If the establishment does not return such product to the evisceration line, then the offline CSI is to complete the applicable PHIS task by writing an NR, citing 9 CFR 381.76(b)(6)(ii)(B);
4. Has a written process in its HACCP system that ensures that all parts, except major portions, are available for offline inspection by the CSI or PHV after reprocessing or salvage activities are completed (9 CFR 381.76(b)(6)(ii)(B)). The CSI or PHV is to inspect all parts. If the establishment does not have a process to allow FSIS to inspect parts, then the CSI is to complete the applicable PHIS task by writing an NR, citing 9 CFR 381.76(b)(6)(ii)(B); and
5. Ensures that the corresponding viscera, feet, and necks are also identified and disposed of in accordance with 9 CFR 381.76(b)(6)(iii)(E) when the online CSI condemns a carcass.

**NOTE:** Individual viscera do not need to be identified if the establishment discards all viscera produced within the time period in which the carcass was condemned by the online CSI.

## **V. PHVs' RESPONSIBILITIES FOR CONDUCTING FOOD SAFETY INSPECTION UNDER NPIS**

A. PHVs assigned to an establishment operating under NPIS are to assess the overall design and implementation of all establishment processes described in the HACCP system and process control procedures in accordance with [FSIS Directive 5000.1](#).

B. The PHV is to work together with the CSIs performing VI and CI to ensure that food safety defects or other conditions do not impair the CI's ability to inspect each carcass. (See section V.H. for instruction on verifying line speed.)

C. The PHV is to review NRs to evaluate when there may be a trend of noncompliances for not removing or properly disposing of carcasses exhibiting likely condemnable animal disease. This trend may indicate that the establishment is not maintaining process control in its sorting procedures (9 CFR 381.76(b)(6)(ii)).

If the PHV finds that the NRs are repetitive with association (linkage), she/he is to follow the instructions in [FSIS Directive 5000.1. Chapter 5. Documentation and Enforcement](#).

D. In establishments that have located their monitoring or CCP to prevent food safety defects from entering the chiller after the online carcass inspection, an NR is not written by the online carcass inspector. Instead the PHV or designee is to perform a directed Poultry Sanitary Dressing task as well as appropriate HACCP and Sanitation SOP tasks to evaluate the overall effectiveness of the establishment's written procedures for preventing fecal and enteric pathogen contamination throughout the slaughter and dressing operations (9 CFR 381.65(f), 381.65(g), and 381.65(h)). If the PHV determines that there is evidence that the sanitary dressing procedures are not in control to prevent contamination, for example, the establishment is relying on reconditioning and reprocessing to remove contamination from product instead of preventing contamination, the PHV is to slow the line speed until sanitary dressing is consistently in control (9 CFR 381.69(c)) and document as appropriate in an NR that sanitary dressing procedures are not being effectively applied. See section V. H. Verification of Evisceration Linespeed.

E. The PHV is to evaluate and assess the situation when notified by the CSIs that persistent unattended non-food safety trim and processing defects are interfering with carcass inspection (9 CFR 381.69 (c)), or that the establishment's sorting process is not in control (9 CFR 381.76(b)(6)(ii)) to meet the RTC definition (9 CFR 381.1). The PHV is to evaluate the situation to determine whether FSIS should take enforcement action as described in [FSIS Notice 38-15](#). The evaluation is to involve:

1. Conducting or assigning directed PHIS Poultry Ready-to-Cook tasks to review establishment records documenting that products resulting from its slaughter operations are meeting the definition of RTC and taking samples according to the instructions in [FSIS Notice 38-15](#);
2. Observing carcasses at the online CI station to determine whether the establishment's process is in control, or whether the presentation of the carcasses is affecting the CSI's ability to inspect carcass-by-carcass (9 CFR 381.76(b)(6)(iii)). See section V.H. for instruction on verifying line speed; and
3. If the PHV determines that the presence of persistent, unattended trim or processing defects evidences that the process is not in control or is interfering with carcass-by-carcass inspection, he/she is to follow enforcement instructions as described in [FSIS Notice 38-15](#).

F. The PHV or designee is to verify that the establishment meets facility requirements that are specific to NPIS (9 CFR 381.36 (f) and 381.76(b)(6)(i)) as often as necessary. The PHV or designee is to issue an NR documenting the noncompliance using the PHIS Other Inspection task if a requirement is not met and citing on the NR the specific applicable regulation.

G. Avian visceral leukosis flock check for young chicken establishments:

1. In young chicken slaughter establishments, the PHV is to verify that the establishment has provided a location at a point along the production line, after the carcasses are eviscerated, at which an inspector may safely and properly inspect the first 300 young chicken carcasses of each flock, together with the associated viscera, for the presence of avian visceral leukosis as required under 9 CFR 381.36(f)(3). The PHV is to verify that the leukosis inspection area meets the other facility requirements in 9 CFR 381.36(f)(3); i.e., that it has a minimum of 200 foot-candles of shadow-free lighting on the surface where the viscera are inspected. The PHV or designee is to inspect the first 300 carcasses of each flock together, with the viscera uniformly trailing or leading or otherwise identified with the corresponding carcass, to determine whether the flock is affected with leukosis. Young chicken establishments are required to notify the PHV or designee prior to the slaughter of each new flock (9 CFR 381.76(b)(6)(iv)).

2. If the PHV or designee finds any lesion compatible with leukosis on the carcass or the viscera, he or she is to instruct the establishment to hang back the carcass and viscera for veterinary disposition. If the disposition of leukosis is confirmed by the PHV, then the PHV is to designate the flock as positive. The PHV is to use professional judgment to expand the sample beyond 300 carcasses or to un-designate a positive flock if leukosis is detected in only one carcass or viscera.
3. If a flock is positive for leukosis, the PHV is to adjust inspection procedures to ensure the adequate inspection of each carcass and viscera and direct the establishment to adjust its processing operations as needed to accommodate the adjusted inspection procedures.
4. If the establishment fails to notify the PHV or designee of the start of a new flock, or if the establishment fails to provide the appropriate facilities for inspection of the 300 carcasses, then the PHV is to use the PHIS Other Inspection task to write an NR citing 9 CFR 381.76(b)(6)(iv) (on leukosis) or 381.36(f) (on facilities), as appropriate, and is to take a regulatory control action (9 CFR 500.2 (a)(3)) at hanging to stop operations.

#### H. Verification of Evisceration Line Speed:

1. The PHV is to verify that the establishment's line speed does not exceed the maximum speed of 140 birds per minute (bpm) authorized for young chickens (9 CFR 381.69(a)) or 55 bpm for turkeys (9 CFR 381.69(b)) as often as necessary to ensure that the online CSI can adequately perform a visual carcass-by-carcass inspection within the time available.
2. The PHV is to measure line speed using physical methods. The maximum allowed line speed is a whole number. Any line speed measurement resulting in a fraction is to be rounded up. If the maximum line speed is exceeded, the PHV is to write an NR using the PHIS Other Inspection Requirements task, citing 9 CFR 381.69, and slow the line to comply with 9 CFR 381.69.
3. The PHV is to assess presentation of birds to the online CSI and evaluate the health status of the flock or other factors that may indicate loss of process control, such as persistent unattended defects, to determine whether these factors are having any impact on the ability of IPP to perform the proper inspection procedures at a given line speed (9 CFR 381.69(c)). If in the judgment of the PHV a carcass-by-carcass inspection cannot be adequately performed, the PHV is to reduce the line speed to a speed at which the online CSI can perform the proper inspection procedures and at which process control can be restored. PHVs are to use the PHIS Other Inspection Requirements task to write an NR citing 9 CFR 381.69(c) and 381.76(b)(6)(iii).

**NOTE:** The CSI is not authorized to slow line speeds, but the online CSI is authorized to stop the line to have carcasses removed from the line that are contaminated with feces or septicemia/toxemia (Sep/Tox) or carcasses warranting the condemnation of the entire carcass as explained in section III.D. The PHV is authorized to reduce line speed.

## VI. POST-MORTEM DISPOSITIONS AND CORRELATION

A. The PHV plays a critical role in ensuring that the public health is protected by verifying that the establishment is effectively sorting. The PHV evaluates the results of the CSI's carcass verification checks and verifies that there is an appropriate disposition of affected carcasses and parts. The final responsibility for disposition determinations rests with the PHV. The PHV is to conduct a post-mortem examination of carcasses or parts that are held for their final examination. The PHV may seek diagnostic assistance from the pathology laboratory and consider the laboratory's report within the context of ante-mortem and post-mortem findings.

B. During work unit meetings, the PHV is to meet with the inspection team as necessary to review pathology and regulatory requirements for addressing food safety conditions (septicemia/toxemia and

fecal contamination) and non-food safety disease conditions warranting condemnation of the entire carcass (e.g., show, explain, discuss, and answer questions).

C. The PHV may utilize the revised “The Entry Training for the PHV” modules on Post-mortem Inspection and Multi-species Dispositions, found at the following link, for correlating.

<http://www.fsis.usda.gov/wps/portal/fsis/topics/inspection/workforce-training/regional-on-site-training/public-health-veterinarian>;

D. If requested by establishment management, the PHV is to correlate with the establishment management on dispositions.

## VII. NPIS POST-MORTEM FORMS DOCUMENTATION

A. Under the NPIS, IPP are to enter in PHIS the total head slaughtered and total head condemned by FSIS or disposed of by the establishment. IPP are not to report condemnation categories.

B. IPP are to enter the number of head condemned by the online and offline CSIs as recorded on FSIS Form 6000-36, NPIS Lot Tally Sheet, and the total head disposed by the establishment, and other slaughter data as recorded on FSIS Form 6510-7, Poultry Lot Information.

**NOTE:** When an establishment has located its CCP or other monitoring control after the CI station to prevent feces from entering the chiller, then the online CSI is to record any finding of fecal contamination on the FSIS Form 6000-36, NPIS Lot Tally Sheet, by entering a hash mark under Special Survey codes found at bottom of the form.

C. If requested by establishment management, the PHV or designee is to generate the FSIS Form 9061-2, Poultry Condemnation Certificate (9 CFR 381.103), by clicking on the “Condemnation Certificate” printer icon in PHIS.

D. The establishment and the PHV, or their designees, are to sign the form and retain a copy after establishment management signs the form. The copy is retained for the current fiscal year plus one additional fiscal year.

**NOTE:** The post-mortem “No. of Head Condemned” category heading in Form 9061-2, Poultry Condemnation Certificate, is updated to reflect the NPIS. The new heading reads “Total No. of Head Condemned/Disposed of.” The number recorded under this heading reflects the total number of head condemned by the inspector and total number of head disposed of by the establishment.

## VIII. QUESTIONS

Refer questions regarding this notice to the Policy Development Staff (PDS) through [askFSIS](#) or by telephone at 1-800-233-3935. When submitting a question, use the **Submit a Question** tab, and enter the following information in the fields provided:

Subject Field:	Enter <b>FSIS Notice 37-15</b>
Question Field:	Enter question with as much detail as possible.
Product Field:	Select General Inspection Policy from the drop-down menu.
Category Field:	Select Slaughter-Poultry from the drop-down menu.
Policy Arena:	Select Domestic (U.S.) Only from the drop-down menu.

When all fields are complete, press **Continue** and at the next screen press **Finish Submitting Question**.

**NOTE:** Refer to [FSIS Directive 5620.1](#), *Using askFSIS*, for additional information on submitting questions.

A handwritten signature in black ink, appearing to read "David Joseph". The signature is fluid and cursive, with a large initial "D" and a stylized "J".

Assistant Administrator  
Office of Policy and Program Development

## **Attachment 1: Identification of Feces for Poultry**

To determine whether an establishment is preventing poultry carcasses with visible fecal material from entering the chilling tank, as required by 9 CFR 381.65(f), inspection program personnel who examine carcasses must be able to properly identify feces.

Three factors—color, consistency, and composition—are essential in identifying fecal material on the inside or outside of poultry carcasses.

- The color of feces ranges from varying shades of yellow to green, brown, and white.
- The consistency of feces is characteristically semi-solid to a paste.
- The composition of feces may or may not include plant material.

Inspection program personnel are to take care to distinguish feces from ingesta.

- The color of ingesta varies with the diet.
- The consistency of ingesta is characteristically solid or granular; digestive fluids sometimes are present.
- The composition of ingesta is identifiable plant material.

(9 CFR 381.65(f) does not apply to ingesta. However, inspection program personnel who find ingesta during fecal contamination checks should notify establishment management to remove ingesta from affected carcasses.)

**Attachment 2:  
FSIS Form 6000-36, NPIS Lot Tally Sheet**

<b>New Poultry Inspection System --Lot Tally Sheet</b>			<b>Shift</b>		<b>Est. No.</b>		<b>Date Inspected</b>	
<b>Class Poultry</b> <input type="checkbox"/> Young Chickens  <input type="checkbox"/> Young Turkeys <input type="checkbox"/> Fryer-Roaster turkeys <input type="checkbox"/> Old Breeder Turkeys <input type="checkbox"/> Young Breeder Turkeys			<b>Class of Poultry if establishment has waiver for NPIS</b> <input type="checkbox"/> Light Fowl <input type="checkbox"/> Heavy Fowl <input type="checkbox"/> Ducks <input type="checkbox"/> Geese <input type="checkbox"/> Capons <input type="checkbox"/> Other (Guineas, Squabs, Pigeons, etc.)					
	No. carcasses condemned by FSIS	No. carcasses condemned by FSIS	No. carcasses condemned by FSIS	No. carcasses condemned by FSIS	No. carcasses condemned by FSIS		Total CD	
	5	10	15	20	25		-----	
Lot No. _____								
Lot No. _____								
Lot No. _____								
Lot No. _____								
Lot No. _____								
Lot No. _____								
Lot No. _____								
Lot No. _____								
Lot No. _____								
Lot No. _____								
Lot No. _____								
Special Survey	Code: 75 Reprocessed birds	Total:						

**FSIS Form 6000-36 (06/18/15)**

**USDA – FSIS**